

Work Order ID 134711

Thursday, July 16, 2015 1:44:31 PM

134711

Page 1

Item ID: PB67-43001-313

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Plate

Start Date: 7/16/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/23/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: mf Date: 5-7-16 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-313	Rev C								

100

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg B67-43001 15-07-16 Prog Rev: C

grain direction along 24.50' **2-Deburr if necessary

(47)

(4)

15-07-16

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

(6) 7

15-07-16

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

(7)

15-07-16

DAS
9
9-89

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Page 2

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NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00							
Brake NC	Bend as per Dwg B67-43001								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									

P.T.O.

DQA#

Date: 15/07/28



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: ~~RA~~

Date: 15/07/27

Work Order update only ☐

Work Order: <u>134711</u> Part No. <u>PB67-43001-313</u> NCR No. <u>15-5226</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☒</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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Date: <u>15-07-22</u>		Step #: <u>100</u>		QTY Effective: <u>⑦</u>		MRB (QSI042) Approval DAS 22 9-89																																																																			
Description Work Order Deviation				Disposition		Completed By 30 9-8: JUL 27 2015																																																																			
Found during bending that part was too long. Part was fabricate per Drawing PB67-43001-313 rev C. R.C. design change				Scrap & destroy. no replace Open PAR to revise drawing. ↓ PAR15-443.		Lead hand / Supervisor Approval Verification DAS 9 9-89 15-07-22																																																																			
						QC / QA Coordinator Approval DAS 9 9-89 15-07-22																																																																			
Root Cause <table style="width:100%;"> <tr> <td>Environment ☐</td> <td>No Re-verification ☐</td> <td>Pressure/Forced ☐</td> </tr> <tr> <td>Design ☒</td> <td>Operator ☐</td> <td>Bending ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Set-up ☐</td> <td>Centre Not Concentric ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td>OTHER: ☐</td> </tr> </table>				Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Design ☒	Operator ☐	Bending ☐	Doc/Data ☐	Offset/Set-up ☐	Centre Not Concentric ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐	OTHER: ☐	FAULT CATEGORY <table style="width:100%;"> <tr> <td>Temperature/Cure ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>☒ Drawing ☐</td> </tr> <tr> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>				Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Countersink ☐	Off-set ☐	☒ Drawing ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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Page 3

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Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Plate

Start Date: 7/16/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/23/2015 Req'd Qty: 6.00

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

SH

JUL 23 2015

15/7/23

MLJ

Picklist Print

Page 1

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Work Order ID: 134711

134711

Parent Item: PB67-43001-313

PB67-43001-313

Parent Item Name: Plate

Start Date: 7/16/2015

Required Date: 7/23/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-06-23 new issue DD verified by:ec
10.10.04 per revC dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.090		Purchased		No		100	sf	40.3250	0.4253	2.686105			

M6061T6S 090

6061-T6 .090 Sheet

07/15/2016

Location

Loc Qty

Loc Code

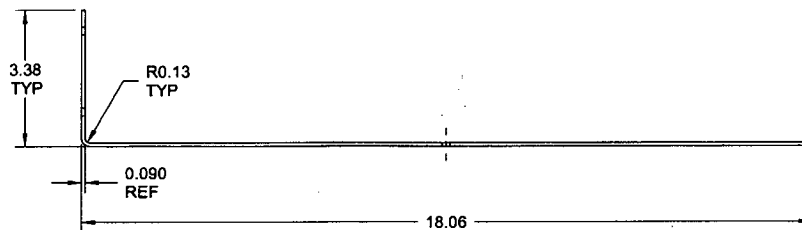
MAT020

40.325

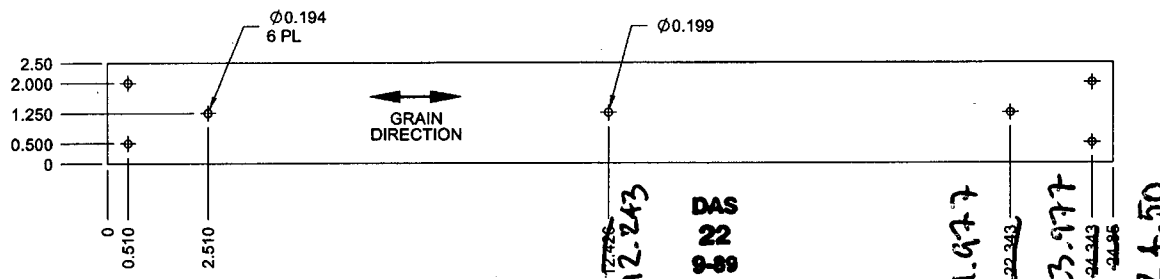
M128435

40.325

3.3



B67-43001-313 PLATE
(MAKE FROM B67-43001-313F)



B67-43001-313F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.090 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027 OR ASTM B209
REF. DART SPEC. M6061T6S.090
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.54 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGES 40 AND 43 PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.			MB	10.04.27
REV.		DESCRIPTION		BY	DATE
DESIGN		RW DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN					
CHECKED		DRAWING NO.		REV.	
MFG. APPR.		B67-43001-313		SHEET 1 OF 1	
APPROVED		TITLE		SCALE	
DE APPR.		PLATE		NT	
DATE		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			
10.04.27					

RELEASED
2010-09-16
AMP

mf
#134711

DAS
22
9-89

21.977

23.977

24.50

DAS
22
9-89

12.243

GRAIN
DIRECTION

Measured by:	Dr
Date:	15/07/16

Measured by:	[Signature]
Date:	15/07/16

Measured by:	[Signature]
Date:	

Drawing	Direction	Tele. No.	Actual Direction	Actual	Revised	Revised	Comments
500		4-06	501	/		Verd-02	
510		4-06	510	/			
1,250		4-06	1,253	/			
2,000		4-06	2,001	/			
2,50		4-030	2,504	/			
2,510		4-06	2,505	/			
2,422		4-06	2,426	/			
22,343		4-06	22,345	/			
24,343		4-06	24,345	/			
24,45		4-030	24,45	/			
Ø 194		-001+005	Ø 194	/			
Ø 199		-001+005	Ø 199	/			

FROM ARTICLE IN SECTION CHIEF

313-

DART AEROPACE LTD	Work Order:	134311
Description: Plate	Part Number:	PB67-4300-313
Inspection Draw: PB67-4300 Rev: C		Page 1 of 1